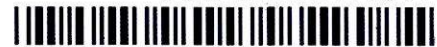




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2580-1
Job Sheet 210175



Part No: D2580-1

Job Qty: 4 pcs

Part Name: 205 Bent Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/29/20

Job Tracking No:

Due Date: 6/12/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2580 REV h SHEETS 1,2,3,8 IPP B 01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C 10.12.01 as per DEO D1 DD ver:ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	4 pcs	6/11/20		0.00	5.12	Skidtubes - 1		TF June 02, 2020
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
101	QC 5	4 pcs	6/11/20		0.00	0.00	QC 5 - 10		BE
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
110	Handfinish - 1-1 Chemical-B4B	4 pcs	6/11/20		0.00	1.33	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S280952



Part: D2580-1

Job No: 210175

Serial No/Batch: S280952

Revision: H

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/03/20

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					Handfinish - 1 - 4 - B4B	TF June 01, 2020
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
120 QC 7	4 pcs	6/11/20	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	mea
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	

					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
					QC 7 - 83	
					QC 7 - 82	
					QC 7 - 87	
125	Skidtubes - 2 - B4B	4 pcs	6/12/20	0.00 1.65	Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	ic
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
130	QC 5	4 pcs	6/12/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	DAS 03 9-89
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
140	Packaging 3-1 - Stock - B4B	4 pcs	6/12/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	DAS 03 9-89
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	

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2-88
03
DAS

2-88
03
DAS

				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
150 QC 21 - SA	4 pcs	6/12/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 9	9-89
Part Op 100 - (Skidtube) 1- Inspect mat'l D2500-1-190 for damage. 2-Drill pilot holes using drill jig DT 8149 A-BC-D 3-Open holes Descriptions: to 0.508" as per Dwg D2580 4-Debur holes per QSI002 section 4.2.3 and blow out all chips from inside of tube 5- Test fit inspection saddles on FWD & AFT saddle holes using DT9916. 101 - (QC5- Inspect part completeness to step on W/O) 110 - (Chemical Conversion Coat per QSI005 4.1) 120 - (QC7-Inspect Chemical Conversion Coat) 125 - (Skidtube) 1- Bond web in place per QSI 015. A/R Sikaflex-291 batch: <u>5268170</u> Sikaflex expire date: <u>21-2-12</u> Start time and date: <u>30-6-8 12 PM</u> bond for 12hrs 130 - (QC5- Inspect part completeness to step on W/O) 140 - (Identify as per dwg & Stock Location: _____) LOCATION : LG002 150 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2500-1-190	Ext'n -I' Beam Tube 4"	4 pcs (1 ea)	100-Skidtubes - 1	5266075	
D2596	Web, 205 Skidtube	4 pcs (1 ea)	125-Skidtubes - 2 - B4B	5281419	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Skidtubes - 1	D2500-1-190	4	20	0	
125-Skidtubes - 2 - B4B	D2596	4	8	0	
Part Specifications					
Specifications could not be found.					

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ITEM	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1				X	D2580-041	SKIDTUBE ASSEMBLY
2				X	D2580-045	SKIDTUBE ASSEMBLY
3				X	D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2580-1-180	EXTRUSION
21	16	16	16	16	D2570	BUSHING
22	1	1	1	1	D2578-3	STEP
23	4	4	4	4	D2579	SPACER
24	16	16	16	16	D2594-1	PLUG
25	16	16	16	16	D2594-3	O-RING
26	1	1	1	1	D2586	206 WEB
27	1	1	1	1	D2585	AFT CAP
28	1	1	1	1	D3664-6	WEARSHOE
29	1	1	1	1	D3664-9	WEARSHOE
30	1	1	1	1	D3664-11	WEARSHOE
31	1	1	1	1	D3664-13	WEARSHOE
32	20	20	20	24	D4202-1	SPACER
33				1	D4406-041	WEARPLATE ASSEMBLY
34				1	D4406-043	WEARPLATE ASSEMBLY
35				1	D5061-1	FWD WEARPLATE
36				1	D5061-3	AFT WEARPLATE
60	60	60	60	60	ALST-1032-130	INSERT
					AK57-1032-130	
					AK54-1032-130	
					AKLS-1032-130	
51	60	60	60	60	AN3CA	BOLT
52	2	2	2	2	AN3-5A	BOLT
53					AN4-45A	BOLT
54	60	60	60	60	NAS1149C0332R	WASHER (AN860C10L)
55	2	2	2	2	NAS1149D0332J	WASHER (AN860D10L)
56					MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- MATERIAL: N/A
- FINISH: CHEMICAL CONVERSION PER DART QSI 006 4.1 PRIOR TO INSERTING D2586 WEB POWER COAT (045) GREEN SANDTEX (REF 4.3.5.1) PER DART QSI 005 4.3
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 006 4.4.
POWDER COAT (045) GREEN SANDTEX (REF 4.3.5.1) PER DART QSI 005 4.3
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.006 TO 0.010 MAX.
- IDENTIFICATION: NONE
- WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- WELDING PER DART QSI 004.
- INSERT D2586 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- USE DART DRILL TEMPLATE D78217 & D78837 ONLY FOR D2580-041/045 TO LOCATE AND DRILL 20.287 HOLES FOR WEARSHOE INSERTS. INSTALL ALST-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3CA BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241-281.
- INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/045 AND 8 PLACES FOR D2580-047/049)
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2586 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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WITHOUT NOTICE

WORK ORDER

NO. 21015

20-05-29

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RCM1-544

REV.	DESCRIPTION	BY	DATE
H	SHEET: PL DELETE D3666-1/6-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -049, -047 WEIGHT UPDATED PER DSI 9986	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PART12-218	DC	13.06.20
E	ADD D2580-047 (2N C-7) AND D2580-7 (2N B3-B) TO CURRENT STANDARDS: D78217 & D78837 WAS	RF	11.06.21
D	CHANGE TO S9 WEARPLATES AND GASKETS, INCLUDE DEO 8124/8183	PH	07.04.06
C	REDRAWN, INCLUDE DEO 9084/ 9087	CP	06.08.26
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.08.16
DESIGN	DS		
CHECKED	SAD		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	17.06.09		

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2580

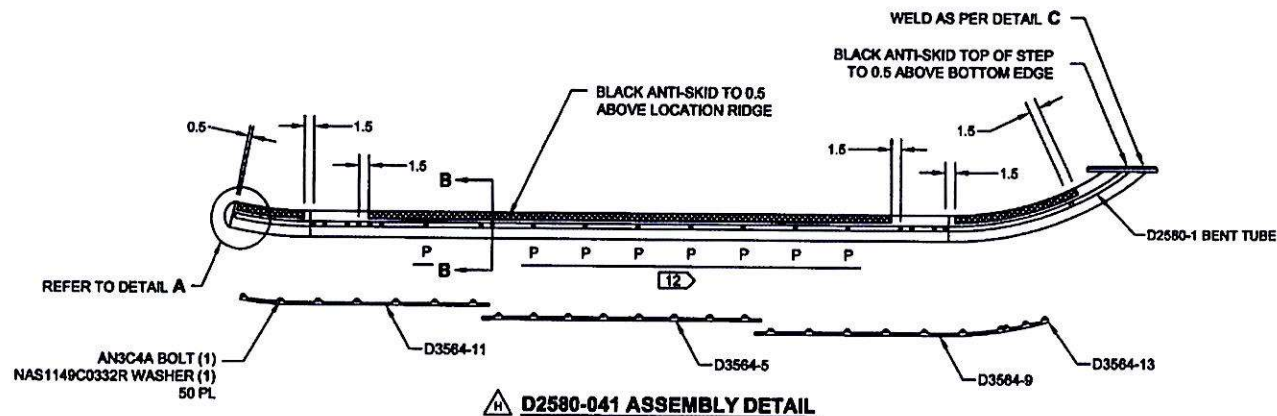
SHEET 1 OF 9

SCALE

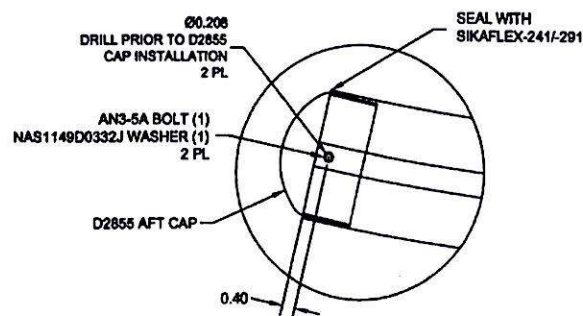
205 SKIDTUBE ASSEMBLY

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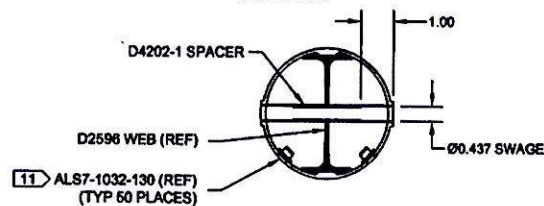
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DETAIL A
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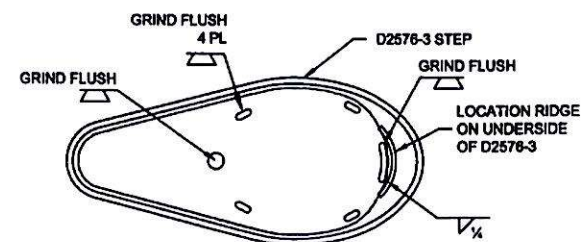


SECTION B-B
SCALE 5X



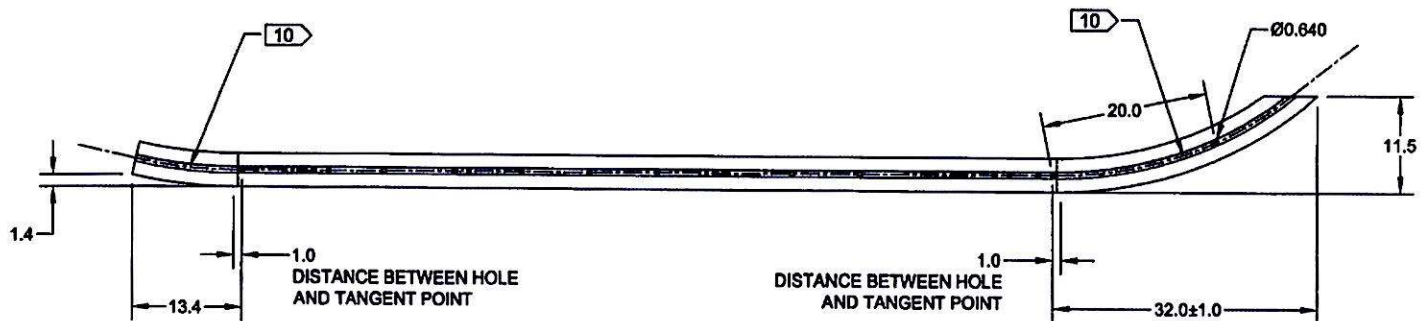
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

DETAIL C
SCALE 5X



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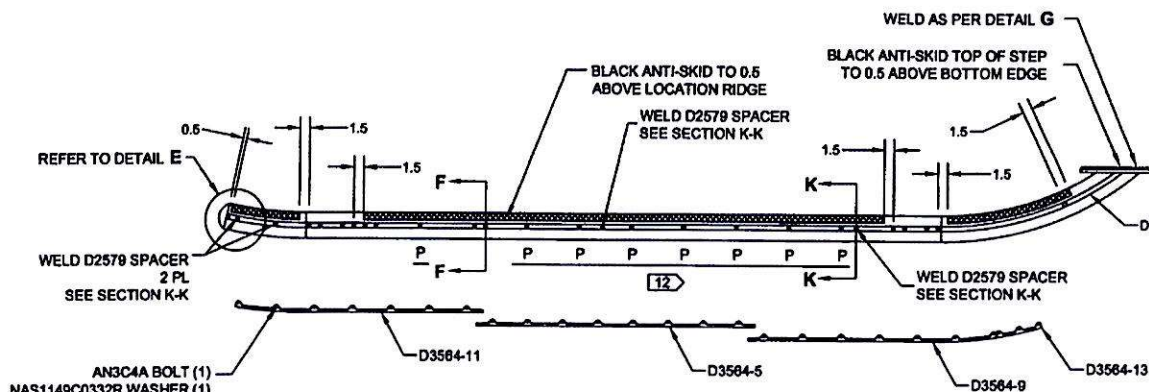
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DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 2 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

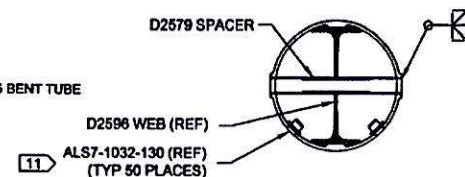
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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 3 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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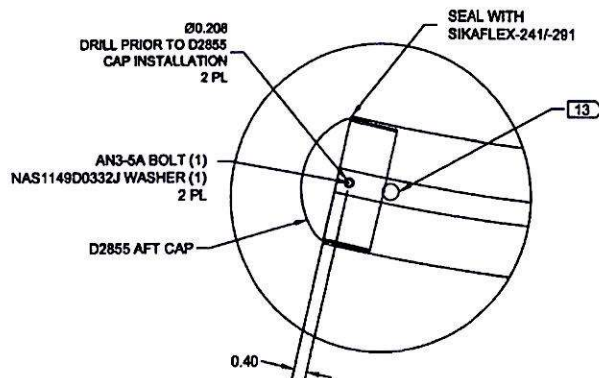
D2580-045 ASSEMBLY DETAIL

**SECTION K-K
SCALE 5X**



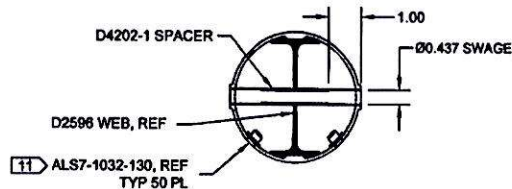
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT C'BORE

**DETAIL E
SCALE 5X**



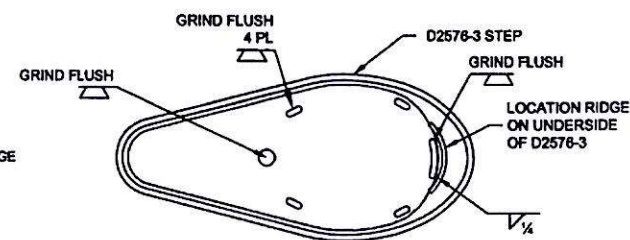
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**SECTION F-F
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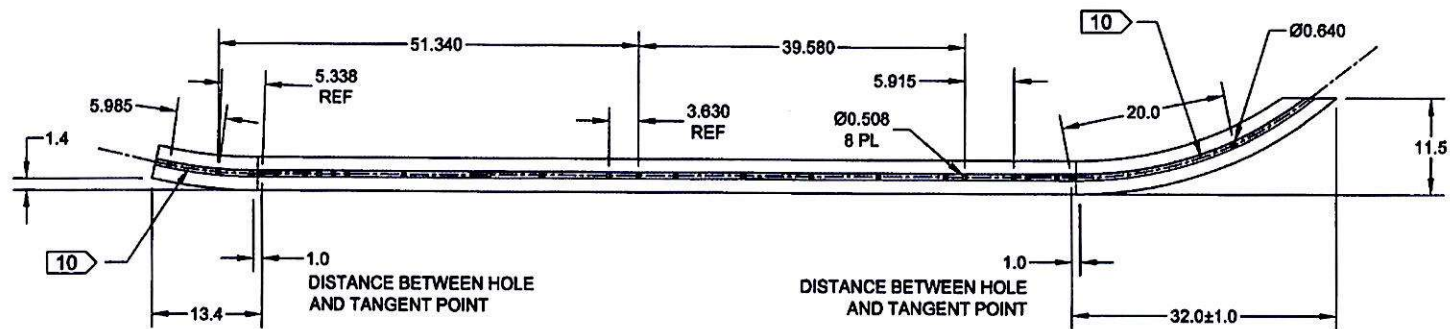


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

**DETAIL G
SCALE 5X**



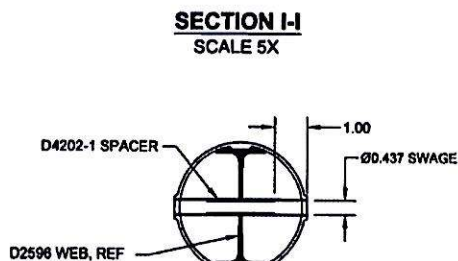
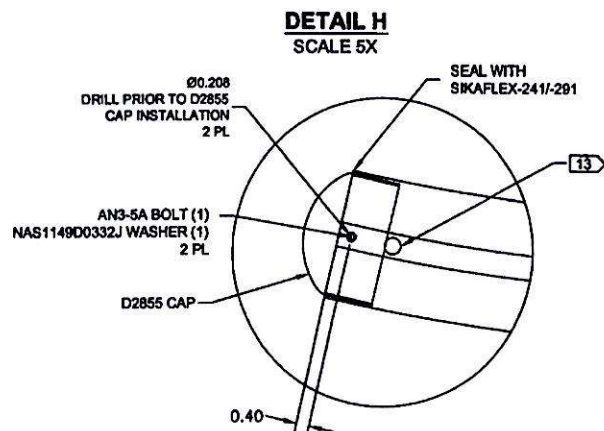
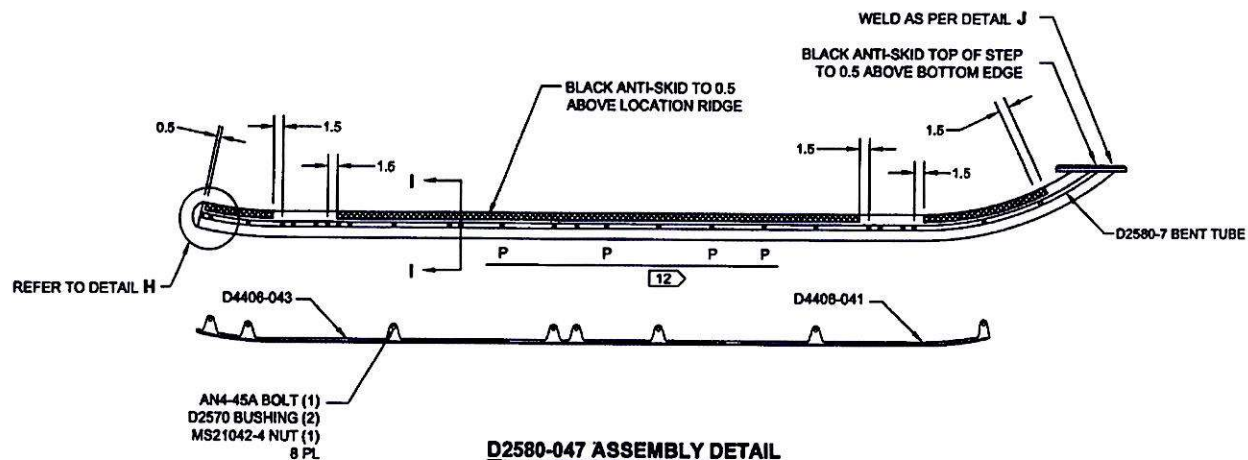
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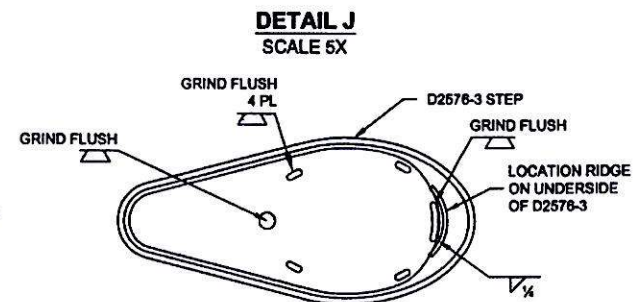
D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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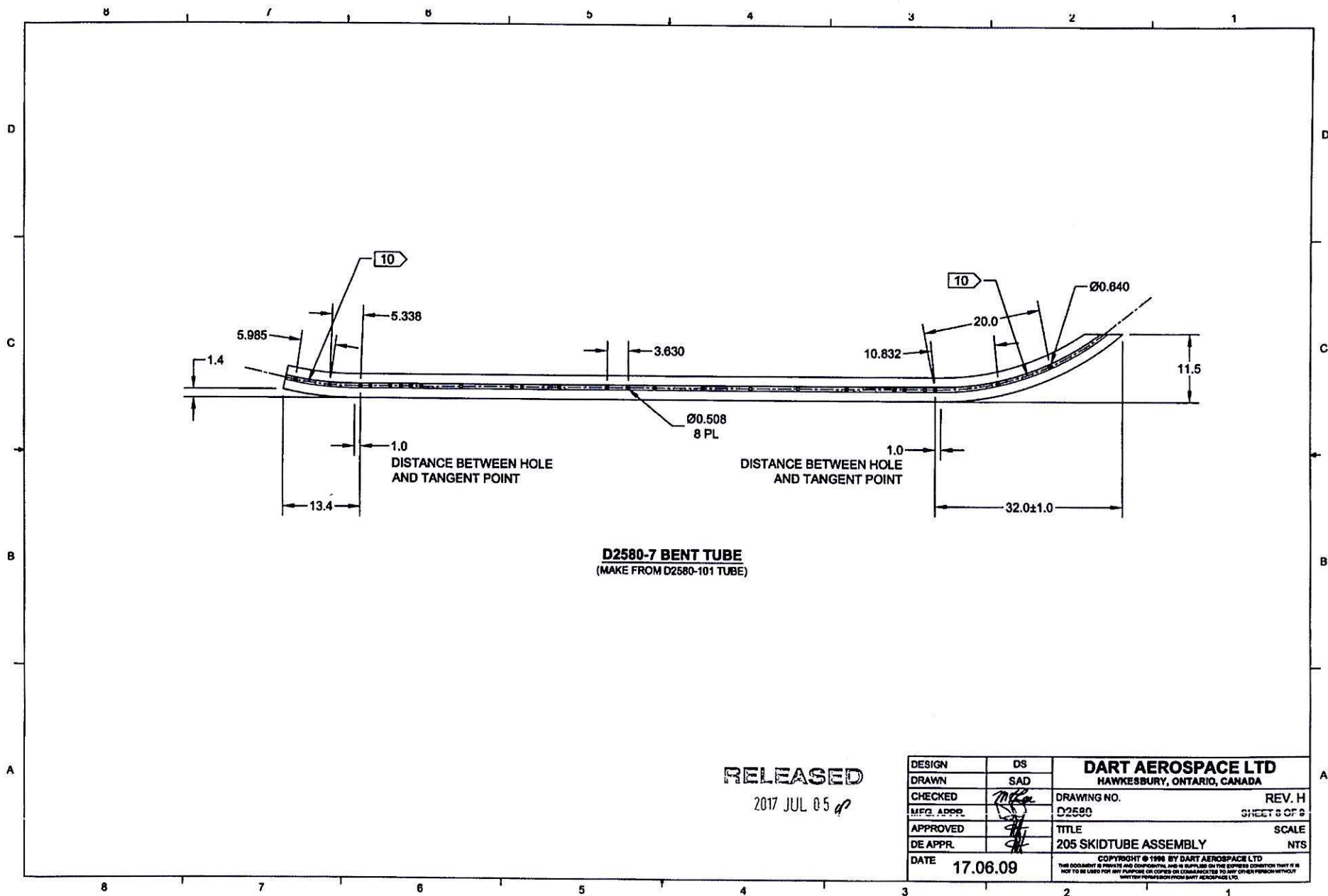
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



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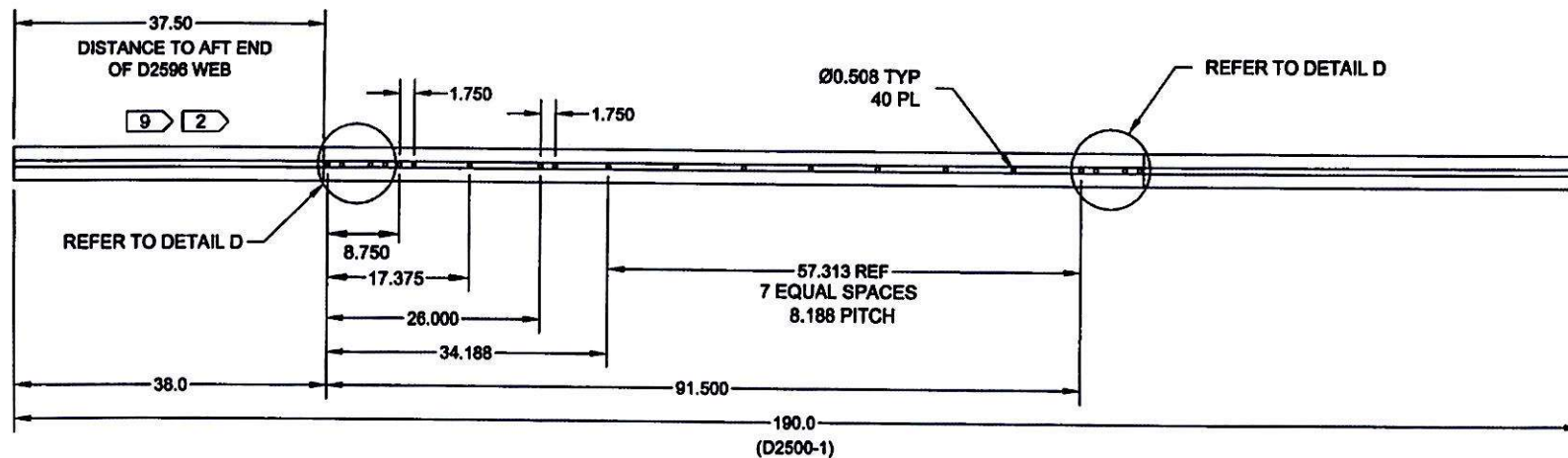
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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 8 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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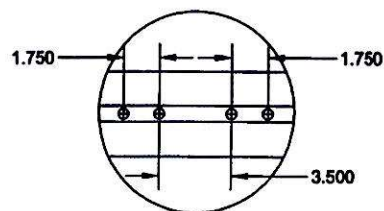


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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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D2580-101 TUBE



DETAIL D
SCALE 5X

RELEASED
2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 9 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					